

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch

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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-009659**Date Inspected:** 05-Oct-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China

CWI Name:	Mr. Chen ying xin/ Mr. Wang xiao bing			CWI Present:	Yes	No
Inspected CWI report:	Yes	No	N/A	Rod Oven in Use:	Yes	No N/A
Electrode to specification:	Yes	No	N/A	Weld Procedures Followed:	Yes	No N/A
Qualified Welders:	Yes	No	N/A	Verified Joint Fit-up:	Yes	No N/A
Approved Drawings:	Yes	No	N/A	Approved WPS:	Yes	No N/A
				Delayed / Cancelled:	Yes	No N/A
Bridge No:	34-0006			Component:	Tower	

Summary of Items Observed:

On this date Caltrans OSM Quality Assurance(QA) Inspector, Baskar Govindarajan, was present during the times noted above for observations relative to the work being performed.

Bay -10

1.This QA inspector, Baskar Govindarajan, observed, ZPMC qualified welding personnel identified as 053049 perform SMAW welding on, Spare strut flange to web, Weld joint no. ED1-A 6003-6-9B. ZPMC CWI Identified as Mr. Chen ying xin . The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-3212-TC-U5B-1.

2.This QA inspector, Baskar Govindarajan, observed, ZPMC qualified welding personnel identified as 052917 perform SAW welding on, spare strut flange plate, Weld joint no. ED1-STSA3-2-109M-1-2B. ZPMC CWI Identified as Mr. Chen ying xin. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-4221-B-U3C-S-1.

Trial assembly area

3.This QA inspector, Baskar Govindarajan, observed, ZPMC qualified welding personnel identified as 067665 perform SMAW repair welding on, south tower, Lift 1, Skin E doubler plate to façade connection plate, weld joint no. SSD1-SA159 C/J-3. ZPMC CWI Identified as Mr. Wang xiao bing. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-345-SMAW-4G (4F)- repair.

WELDING INSPECTION REPORT

(Continued Page 2 of 2)

4.This QA inspector, Baskar Govindarajan, witnessed, ABF personnel's performing Magnetic particle examination in 23 mtr. Elevation of East tower, Lift 1 and 65 mtr. Top of South tower, Lift 2. All indications marked by ABF personnel's have been noted down in respective weld maps for record.

Machining area

5.This QA inspector, Baskar Govindarajan, observed, ZPMC qualified welding personnel identified as 066479 perform SMAW surface repair welding on, East tower, lift 3, skin C. ZPMC CWI Identified as Mr. An qing xiang . The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-345-SMAW-3G (3F)-Repair.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

Summary of Conversations:

No relevant conversations.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Serge, Sinevod - 134-8257-0045, who represents the Office of Structural Materials for your project.

Inspected By:	Baskar,Govindarajan	Quality Assurance Inspector
Reviewed By:	Clifford,William	QA Reviewer
